

5/44

DART AEROSPACE LTD	Work Order:	24497
Description: 206 Extrusion Bending	Part Number:	D2620
Drawing: D2620 Rev. B	Qty:	36

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	DP	05.10.12	30
2	LG	Bend D2600-1 extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio FT008 Batch 220534	DP	05-11-21	36
3	LG	Cut Fwd end of tube as per Dwg D2620	DP	05-11-21	36
4	QC5	Inspect for Completeness on the W/O	BE	05-11-21	36
5	LG	Identify and Stock in LG Cell	DP	05-11-21	36
6	AC	Cost/Part: 34.01	SUT	05-11-22	36
7	DC	Close W/O 36,25 Inspect Level 21	DP	05/11/22	36

Rev	Date	Change	Revised By	Approved
A	97.12.03		BW	
B	98.09.09	Bending now in-house	KS	
C	99.06.04	Re-format, Added cut	DM	
D	02.07.26	Change Dwg to rev.B; Updated Location	RF	KJ. 91

RELEASED  
02/08/15 RF

600-1-160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

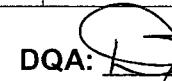
Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA: 

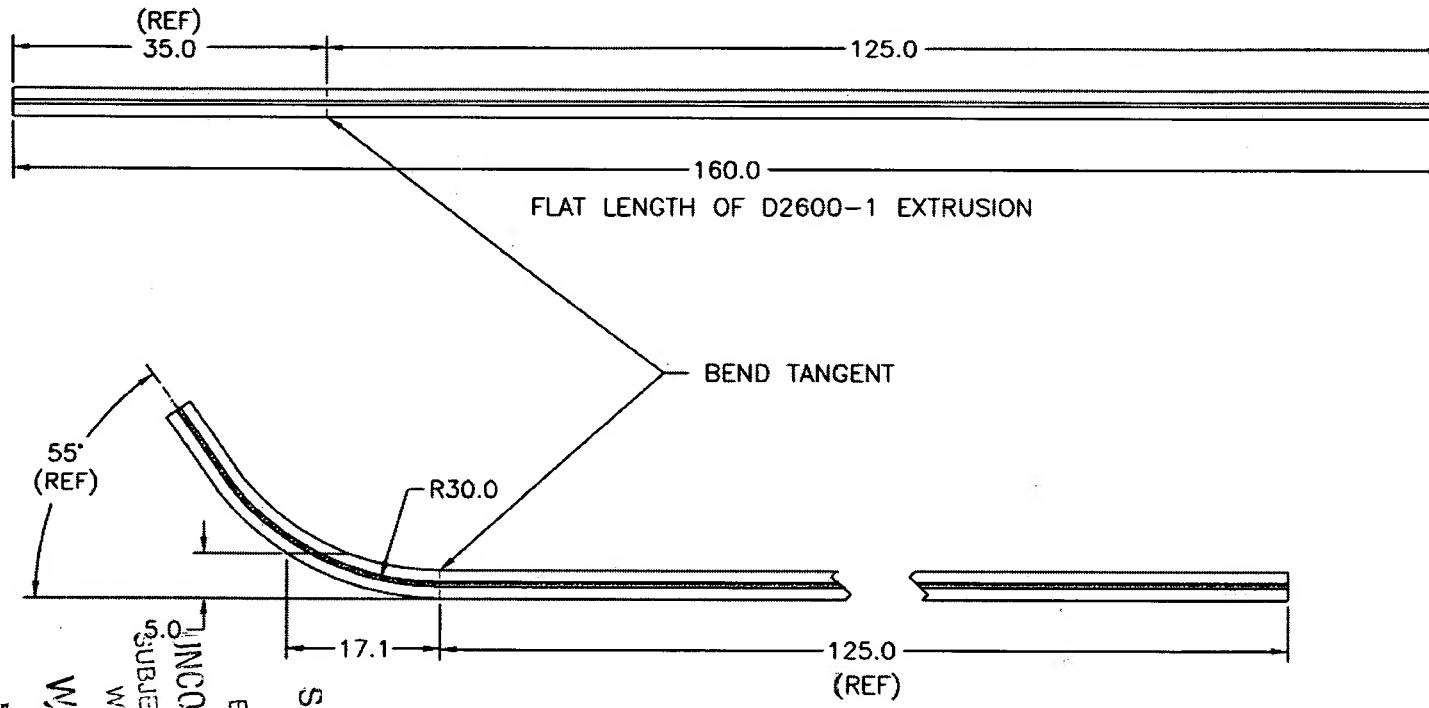
Date: 05/11/22

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

SPECIFICATION CONTROL DRAWING  
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
3. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
4. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
5. TUBE WIDTH SHOULD BE  $3.20 \pm 0.20$  IN THE BEND.
6. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
7. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.20$  IN THE BEND.
8. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

WORK ORDER  
NO. 2449

**DART**



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FARNSWELL INTERNATIONAL AIRPORT, WA
DATE	DRAWING NO.	REV. B
99.09.10	D2620	SHEET 1 OF 1
A	97.11.07	SCALE
B	97.09.10	1:20
	UPDATE FOR IN-HOUSE BENDING	

**RELEASED**  
44-04-15 DS

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 11, 2005  
07:41 am

Work Order No	:	0024497	Department Code:		
Project Name	:	D2620	Burden Flags	:	NNNNNNN
Project For	:	WK544	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2620	Invoice Number	:	
Description	:	Bent 206 Skidtube	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	30	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	10-08-05	Est Mark Up	:	0.000%
Est Finish Date	:	11-05-05	Actual Mark Up	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden	:	0.00	0.00	0.00	0.00
=====		=====	=====		
Total Cost	:	0.00	0.00	0.00	
Mark up	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
12:20 pm

Work Order No : 0024497  
 Project Name : D2620  
 Project For : WK544  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2620  
 Description : Bent 206 Skidtube  
 Manufactured : Yes  
 Amount Req'd : 30  
 Amount Done : 0  
 Start Date : 10-08-05  
 Est Finish Date : 11-05-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.75	100.00		
Production Cost	0.00	15.20	100.00	0.00	15.20
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	15.20	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	15.20			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	( -15.20 )

MIS 0/B  
n  
11.13



Date: Monday, 14/11/2005 8:28:13 AM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 EXTRUSION BENDING		
Job Number	: 24497		Part Number	: D2620		
Estimate Number	: 10311		Drawing Number	: D2620 REV B		
P.O. Number	:		Project Number	:		
This Issue	: 14/11/2005	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : LANDING GEAR	Due Date	: 30/11/2005	Qty:	30
Previous Run	:		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26001	Extrusion Round 3" 206
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg.D2620 using CNC Bending Machine program 206.A  
 and Folio Ft008  
 2- Cut Fwd end of tube as per Dwg.D2620

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: \_\_\_\_\_

5.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion	
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